

Date: Monday, 7/9/2007 11:52:27 AM  
 User: Kim Johnston

## Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 33393  
 Estimate Number : 10268  
 P.O. Number : *N/A* Part Number : D350636014 *CB*  
 This Issue : 7/9/2007 S.O. No. : *N/A* Drawing Number : D2750 ~~UNDER REVIEW~~ *07.07.09*  
 Prsht Rev. : *NO* Project Number : *N/A*  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 32533 Material : *N/A*  
 Written By : Due Date : 7/30/2007 Qty: 1 Um: Each  
 Checked & Approved By : *Am. 07.09*  
 Comment : Est Rev: H 02.09.25 Rearranged procedure steps KJ  
 Est Rev: I 05.12.08 Rearranged procedure steps EC  
 Est Rev: J 06.03.30 Per rev. D EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



*KS 07.07.09* *1*

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 002

*S. 7/10/31*

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

*13 32 448 R 7-8-9*

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

*B 22584*

*BE 07-09-28*

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

*R 7-8-9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750 .

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *M 105138 BE 07-09-28*

10-Grind welds flush as per Dwg D2750

11-Countersink Detail A as per dwg D2750.

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*11) 07-10-04*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8 07/10/04*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*11 7-10-4*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BE 07-10-05*

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

*B32874 ① 11*

*7-10-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

JK 7-10-16

11-Deburr holes

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-17 (D)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/17

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

BL 07-10-25 (D)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

07-10-24 (D)

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: M103954

2.44

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

52 07-10-24 (D)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

5 07/10/24

52 07-10-24 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B33059

*ys*

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B31889

*yl*

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B29337

*yl*

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B32991

*yl*

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 3x2 batches { 6x = 30817 } { 2x = 32990 }

*ys*

26.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 3 B332233

*yl*

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B32996

*yl*

*07-10-24*

*yl*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1332599

NY

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M105906

JS

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105057

JS

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103668

JS

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M104937

JA

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671

JS

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105906

JS

07-10-24

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M105408

*MS*

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

*MS*

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M104625

*MS*

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M105408

*MS*

*X*

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M105430

*MS*

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: M105585 08.07

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M105005

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M105585

*MS* 08.10.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

EXP DATE: 08-07

5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

HD 07-10-25 @

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EA/10/26

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B33083

AS 07/10/30

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106043

AS 07/10/30

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104625

AS 07/10/30

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104605

AS 07/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: JD Date: 8/14/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 33393

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104955

AS 07/10/30

48.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B34820

AS 07/10/30

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

E 7/10/31

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

NEUF 07/10/31

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/02

Job Completion



07/10/31

B33393

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

RELEASED  
06.02.07 *PH*

UNDER REVIEW *OK*  
*CB*

07.02.05 *CB*

*add gaskets  
change to SS wearplates*

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *33393*

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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

**UNDER REVIEW**

07-02-05 CB

SS wearplates

OK  
CB

**RELEASED**  
06-02-07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ - $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

SHOULD  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33392

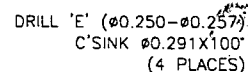
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ok  
CB

07.02.65 (8)  
SS warplates

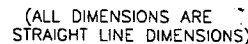
RELEASE  
06-02-07



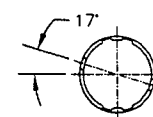
DETAIL E

DETAIL C

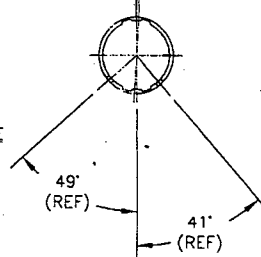
- DRILL 'E' (Ø0.250-Ø0.257) WEARSHOE HOLES  
USING DRILL TEMPLATE DT8108-1  
PER SECTION F-F (42 PLACES). 1.770  
USE DT8108-2 FOR DT250-2.  
C'SINK Ø0.391x100" WEARSHOE HOLES  
(38 PLACES)  
**DO NOT CINK D3488-Ø41/-Ø42 HOLES**



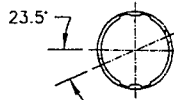
(FROM WEARSHOE CL  
TO SKIDTUBE CL.)  
0.110



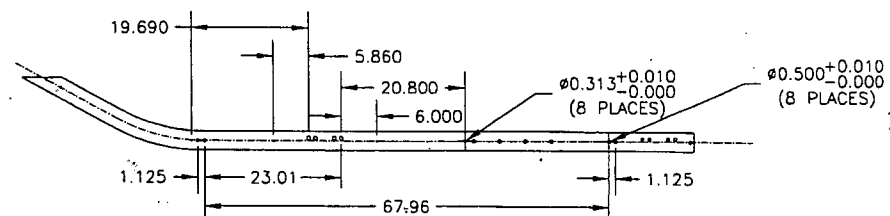
SECTION E-E



SECTION F-F



SECTION R-R



D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)  
D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND  
GROUND HANDLING HOLES

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WORK ORDER  
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CHECKED

APPROVED	
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DRAWING NO

02750

REV. D

DATE \_\_\_\_\_

[illegible]

02750	TITLE
	350 SKIDTUBE ASSEMBLY

SCALE

SCALE

1.22

REVIEW

Ed 05-08  
06-02-07

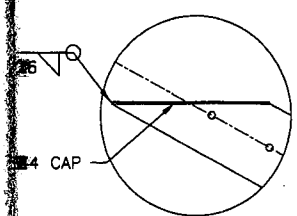
CB

SEE DET. Q  
DETAIL G

INSTALL NAS1330S3KB166  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

RELEASED  
06-02-07

DETAIL G



USE AN3C7A BOLTS  
FOR INSTALLING AFT  
D2648-3 WEARPAD  
(4 PLACES)

AN3C5A BOLT (1)  
AN960JD10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

INSTALL NAS1330S3KB166  
INSERTS (4 PLACES)  
AFTER FINISH

D2750-041/-042 ASSEMBLY  
D2750-041 (SHOWN D2750-042 OPPOSITE)

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SKAFLEX-241 ADHESIVE PER DART QSI D15.  
NOTE: ENSURE THAT HOLES LINE UP.

SEE DET. P  
SEE DET. N  
D3488-041  
(OR D3488-042)

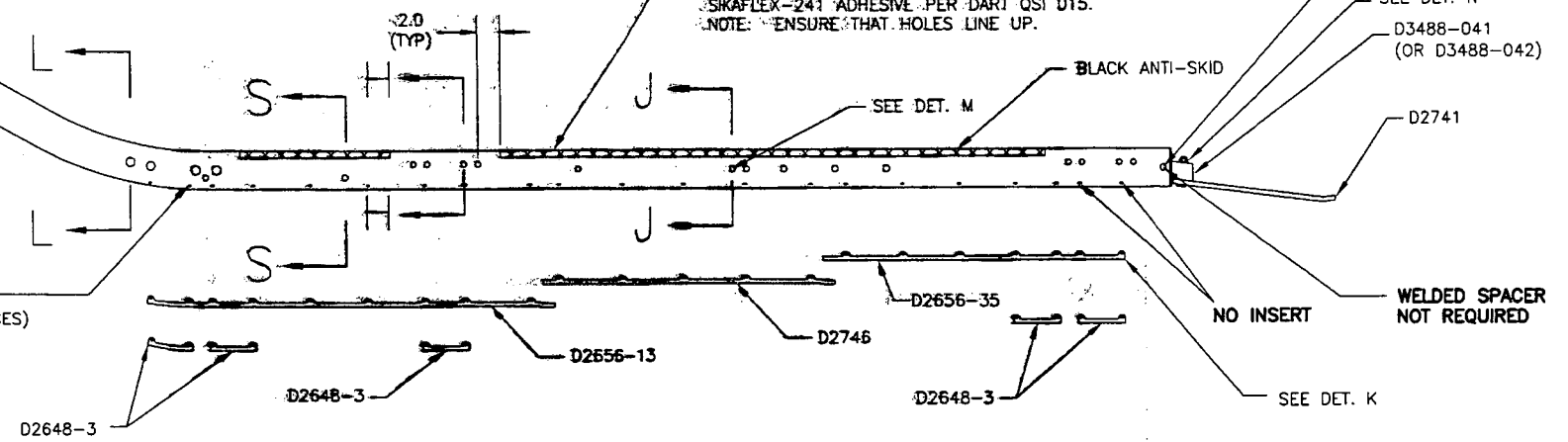
BLACK ANTI-SKID

SEE DET. M

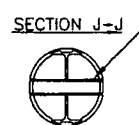
D2741

NO INSERT  
WELDED SPACER  
NOT REQUIRED

SEE DET. K

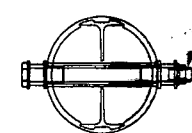


SECTION H-H



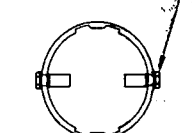
- WELDING INSTRUCTIONS
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2743 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. DRILL OUT SPACER TO Ø0.484
  6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



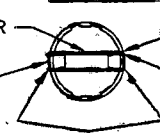
- AN6-44A BOLT (1)  
D2745 BUSHING (2)  
NAS1515H8L WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)  
NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

DETAIL Q



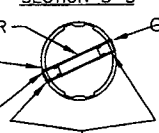
- AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

SECTION L-L



- D3490-3 SPACER  
Ø0.750 HOLES ONLY  
D3492-043 PLUG ASSEMBLY

SECTION S-S

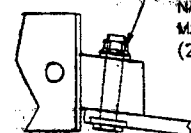


- D3490-1 SPACER  
Ø0.500 HOLES ONLY  
D3492-041 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N



- AN8C21A BOLT (1)  
AN960JDB16L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

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CHECKED #		APPROVED #		DRAWING NO. D2750	REV. 0
DATE 06.01.05				TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

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UNDER REVIEW

01.02.05 CB

OK CB

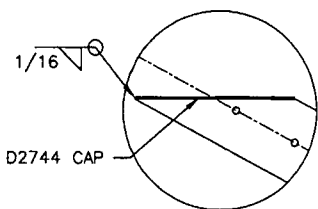
SEE DET. Q

DETAIL G

INSTALL NAS1330S3KB166  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

RELEASED  
06.01.07.11

DETAIL G



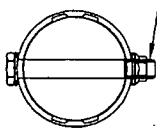
DETAIL K



USE AN3C7A BOLTS  
FOR INSTALLING AFT  
D2648-3 WEARPAD  
(4 PLACES)

AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

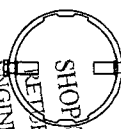
DETAIL P



AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

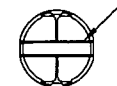
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06.01.07.11

DETAIL Q



AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

SECTION H-H



D2743 SPACER (REF)

(TYP)

SECTION T-T



D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

SECTION U-U



D3490-5 SPACER

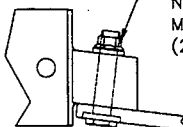
Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

DETAIL N



AN8C21A BOLT (1)  
AN960JD816L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

D2750-043/-044 ASSEMBLY  
D2750-043 SHOWN (D2750-044 OPPOSITE)

BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

SEE DET. P  
SEE DET. N

D3488-041  
(OR D3488-042)

BLACK ANTI-SKID

SEE DET. M

D2741

D2656-35

NO INSERT

WELDED SPACER  
NOT REQUIRED

SEE DET. K

D2648-3

D2746

D2656-13

D2648-3

D2648-3

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CHECKED #	APPROVED #	DRAWING NO. D2750
DATE 06.01.05	TITLE 350 SKIDTUBE ASSEMBLY	REV. D SHEET 5 OF 5 SCALE 1:20



NO. 130

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliot  
Joint Welding Procedure t.g  
Part number and Job number D350 630 011 / B33961

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS t.g  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-0-09

Qualifier P.A. Dool